

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019807**Date Inspected:** 21-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

TRIAL ASSEMBLY

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Li Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component; Segment 11AE

PCMK: CA082-001

Welder: 040320

WPS-345-SMAW-4G(4F)-FCM-Repair-1

Weld Repair-B-WR-16072

Component; Segment 11 BE

PCMK: SEG068A-044

Welder: 044515

WPS-345-SMAW-4G(4F)-FCM-Repair-1

Weld Repair- B-WR-16073

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Ultrasonic Testing (A,B,C and D-Scan)

This Caltrans QA inspector performed 10% Ultrasonic Testing (UT) verification that was previously tested and accepted by ZPMC Quality control personnel. The members tested were the transverse weld splice joining the deck plates for segments 11AW to 11BW weld number OBW11-003. This QA inspector used the conventional scanning patterns A, B, C, D and E on the previously inspected welds. This QA inspector performed his QA verification after ABF had tested the weld and concurs with ABF's evaluations. The results were recorded onto the documentation sheet according to the rejection criteria of "D" Scan procedure. Caltrans and ABF jointly filled out the documentation for this location, on this date. At the time of the QA verification no rejectable indications were noted at the scanned area.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
